Work Orde		0267		*100267*											
Revision ID: Item Name:	D4009-041 Bonding Braid 5/01/13 5/01/13	Start Qty: 4.00 Req'd Qty: 4.00	- *4*	Accept	*N900 Cust Item I Customer:		100)*	Setup	Start Stop	ı vı .	S1* S2*			
Approvals:	Process Plan	n: <u>µ</u> (5	Date: \\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	Y Tooling: SPC (Y/N):		ate:			Run	Start Stop	1/11	R1* R2*			
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt		Reject Number	Insp. Stamp			
Draw Nbr	Rev	ision Nbr				•									
D4009	A											_			
*100 *100* Small Fab Small Fab		Mem o assemble	as per dwg D4009	0.00				10x				J3	·/os		
*110 *110* QC Quality Control		QC5- Inspect part con	mpleteness to step on W/O	0.00 3 5 5	7			6							
120 *120 Packaging		Identify as per dwg &	stock Location:	0.00 - CPG				(OX				82			

Packaging

											DQA:	υ	ate.	
NCR: Y	es / No				WORK ORDER NON-C	10:	NFORM	MANCE / UP	DATE		QA Closed:		ate:	
Work Orde	nr.				DISPOSITION				AGAINST D	_	PARTMENT	 		1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
Part No					Rework Scrap Use-as-is Work Order Update			Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite						Engineering Quality Other
Root				Descri	ption of work order update	ı	nitial	Ac	tion		Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verificati	on ·	QC Inspector
Doc/Data													ļ	
Equip/Tooling						ļ								
Operator						İ								
Material														
Setup														
Other														
Process				:										
Supplier														
Training											,			
Unapproved		1				L					Ļ	<u></u>		
					F/	AUL	T CATE	GORY						
Landir	ng Gear				General	_	7		Γ-		1			1
	Bending			<u>_</u>	Bend	_	Grain		ļ	_	Ovalized			Pressure/Forced
	Centre	Not Conce	ntric to	o/s	BOM/Route	_	Hardwa		L		Over/Under		\square	Temperature/Cure
	Cracks				Broken/Damaged	L	4	on incomplete	L		Part Incorred		-	Weld
	Crushed	l/Crimped			Burrs	Ŀ	4	ions Incomplete/	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
	Cuffs				Contamination	<u></u>	Mainte		L	_	Part Moved			
	Heat Tr	eat			Countersink		Mislabe	led	L		Positioned V	-		1
	Inspecti	on Strip ir	1 Tube		Cut Too Short		Misread	i	L		Power Loss/	Surge		Other
	Rinnles	in Rend		1	Drill Holes	1	Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Work Order ID 100267 April-22-13 12:52:18 PM								Page 2					
Item ID: Revision ID: Item Name:	D4009-041 Bonding Braid			Accept	*N900	040	100)* s	Setup	Start Stop		S1* S2*	
Start Date: Required Date Reference:	5/01/13 : 5/01/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:							
Approvals:	Process Pla	n:	Date:			nte:		I	Run	Start Stop		R1* R2*	
Sequence ID/ Work Center I 130 *130* QC Quality Control	D	Operation Description QC21- Final Inspection Memo	- Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Qt	y	Reject Number ろつく	Insp. Stamp	

pl13-05-8

										DQA:	Date	ii
NCR: Y	es / No				WORK ORDER NON-C	ON	NFORM	MANCE / UP	DATE	QA Closed:	Date	:
Work Orde					DISPOSITION			- 	AGAINST D	EPARTMENT		
Part N	lo				Scrap Machining Small Fall Use-as-is Thermoforming Finishing			Crosstube Small Fab Finishing Composite	 i	Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
WCIV IV					work order opdate	'		201,86 1 02				
Root					ption of work order update	ļ.	nitial		tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data		l				1						
Equip/Tooling										-		
Operator		1				l						
Material												
Setup		İ				İ						· ·
Other												
Process												
Supplier		1										·
Training												
Unapproved		<u></u>	}									
						AUL	T CATE	GORY				
Landir	ng Gear			<u></u>	General		l		_	¬₋	Г	٦
· I	Bending			<u> </u>	Bend	\vdash	Grain		<u> </u>	Ovalized	-	Pressure/Forced
	Centre N	ot Conce	ntric to	o/s _	BOM/Route	Ш	Hardwa		<u> </u>	Over/Under	<u></u>	Temperature/Cure
	Cracks				Broken/Damaged	Щ	•	on Incomplete	-	Part Incorre	<u> </u>	Weld
	Crushed/	'Crimped		<u> </u>	Burrs		1	ions incomplete/	Unclear	Part Lost/M	_	Wrong Stock Pulled
	Cuffs				Contamination		Mainte		<u> </u>	Part Moved		
	Heat Tre			<u> </u>	Countersink	<u> </u>	Mislabe		<u> </u>	Positioned		٦
	Inspection	•	Tube		Cut Too Short		Misread	i	L	Power Loss,	/Surge	Other
	Ripples ii	n Bend			Drill Holes		Offset					·

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

April-22-13 12:52:18 PM

Work Order ID:

100267

Parent Item:

D4009-041

Parent Item Name:

Bonding Braid

Start Date: 5/01/13

Required Date: 5/01/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP rev A 10.02.02 new issue Prelim EC verified by:DD

IPP Rev:B 10.05.03 as per ECN10-

Component Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on e Hand	Qty per Kit	Total Qty	Qty Date Status Issued Issued
4009-1 erminal End		Manufactured	No			100	Each	3.0000	2	8	13/05/0
				Location		Loc Qty	<u>I</u>	Loc Code			
				ST083		3				 /	M100332
				826	559	3				3	
1009-3 ound Strap		Manufactured	No			100	Each	7.0000	1	4	5/3/05 K
ound Strap				Location		Loc Oty	ī	Loc Code		Anna's BY also	9-1-1
				GA		5	1	Cot Coue			Bis - 21 0
				858	388	1					B101234 (
•				985	565	4					
				ST084		2					
4000 5			NI	725	536	2	F1	1.0000			
4009-5 round Strap		Manufactured	No			100	Each	1.0000	ļ.	4	1/3/05/
ound Strap				Location		Loc Qty	ı	Loc Code			
				ST084		<u>===- </u>	-				B100422 (10
				725	537	ı					
4009-7		Manufactured	No			100	Each	83.0000	1	4	Il a lor la
ab		•							Constitute them.	· 21 · 152 · 1 · 2205 · 20	C/J/3/05/0
				<u>Location</u>		Loc Qty	<u>I</u>	Loc Code			
				ST083	125	83					
				621 956	644 	2 81				10	
4009-9		Manufactured	No			100	Each	14.0000	1	4	DK a last
eceptacle									<u> </u>	· +···	
				Location		Loc Qty	<u>1</u>	Loc Code			
				ST084		14					
				726		1				10	
				859	979 -	13				10	

												DQA:	D	ate:	
NCR:	⁄es	/ No				WORK ORDER NON-C	O	NFORI	MANCE / UP	DATE		QA Closed:		ate:	·
						DISPOSITION				AGAINST	DE	PARTMENT			
Work Orde	er: _	· <u>·</u>				Rework			Skid-tube	Crosstube		1	Water Je	t [Engineering
Part N	No.					Scrap			Machining	Small Fab		1	d. Eng. Coor	-	Quality
NCR I	No.					Use-as-is Work Order Update		Thern	noforming Large Fab	Finishing Composite		Rec/Stor	e/Packaging Supplie	_	Other
Root					Descri	ption of work order update	I	nitial	Act	tion		Sign &			
Cause	1	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	on	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process															
Supplier Training Unapproved															
Опарриотеа			I	<u> </u>	1	F	AUL	T CATE	GORY						
Landi	ng G	Gear		****		General						-			•
		Bending				Bend		Grain				Ovalized			Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route	L	Hardwa				Over/Under		<u> </u>	Temperature/Cure
	L	Cracks			<u> </u>	Broken/Damaged	<u></u>	1	ion Incomplete			Part Incorre		—	Weld
	-	Crushed/	Crimped			Burrs		4	tions Incomplete/	Unclear		Part Lost/Mi	ssing	L_	Wrong Stock Pulled
		Cuffs			L	Contamination	_	Mainte				Part Moved			
		Heat Trea			<u> </u>	Countersink	\vdash	Mislabe				Positioned V	_		1
		Inspectio	n Strip in	Tube		Cut Too Short		Misrea	đ	l		Power Loss/	Surge		Other
l		Ripples in	Bend			Drill Holes		Offset							

Out of Calibration

Out of Sequence
Outside Dimensions

Turning Sequence

Wave/Twist in Tube

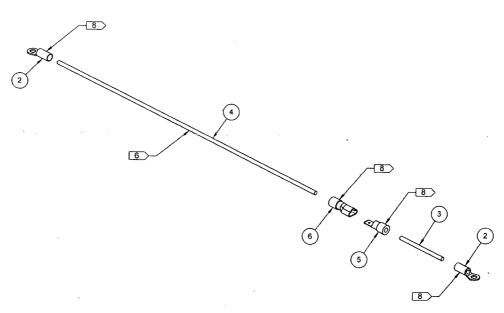
Torque Waves in Extrusion

Drawing

Finish

Folio

IJEM NO.	OTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION
· 1 1	x:	D4009-041	BONDING BRAID	JCA-M47-4-01
2	2	D4009-1	TERMINAL END	
; 3	1.	D4009-3	GROUND STRAP	
4	1	D4009-5	GROUND STRAP	
5	1	D4009-7	TAB	
6	1	D4009-9	RECEPTACLE	



THEOLIG

D4009-041 BONDING BRAID

С

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4009-041" AND B/N USING D2729-1 LABEL INSTALLED WITH D2182-045 HEAT SHRINK
7) WEIGHT: N/A
8) USE CRIMPING TOOL P/N 59824-1

- A NEW ISSUE 10.02.05 REV. DESCRIPTION DATE BY DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D4009 MFG. APPR. SHEET 1 OF 5 APPROVED TITLE SCALE **GROUND STRAP** DE APPR. COPYRIGHT © 2010 BY DART AEROSPACE LTD

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